

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018271**Date Inspected:** 17-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Tony Sherwood**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

1) At weld joints 6E/7E-D1, inside the OBG section: ABF welding personnel Fred Kaddu (#2188) was excavating the weld for repair purposes. Please see below for details.

2) At weld joints 7W/8W-E1, inside the OBG section: ABF welding personnel Song Tao Huang (#3794) was performing production welding using the Flux Cored Arc Welding (FCAW) process. QC Inspector Tony Sherwood was present and monitoring the work.

At weld joints 6E/7E-D1, inside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) using a grinder to excavate the weld for repair purposes. The excavation area started at weld joint "C" and proceeded for approximately 1040 mm. At 0800 the excavation had just been started. Towards the end of this QA Inspector's shift the excavation was still in progress and at this time the excavation was 1040 mm in length, 20 – 25 mm wide and approximately 10 -12 mm deep. This QA Inspector informed QA Inspector Jojo Lizardo of the work in progress during a turnover at the end of the shift.

At weld joints 7W/8W-D1, inside the OBG section this QA Inspector observed ABF welding personnel Song Tao

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Huang (#3794) performing FCAW production welding using a track system. This QA Inspector performed a verification of the welding parameters observing the following; 252 amperes and 23.5 volts with a travel speed of 275 mm per minute. The welding observed appeared to comply with ABF-WPS-D15-3042B-1. This QA Inspector observed QC Inspector Tony Sherwood in the area and monitoring the work being performed.

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mohammad Fatemi (916) 813-3677, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hager,Craig	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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